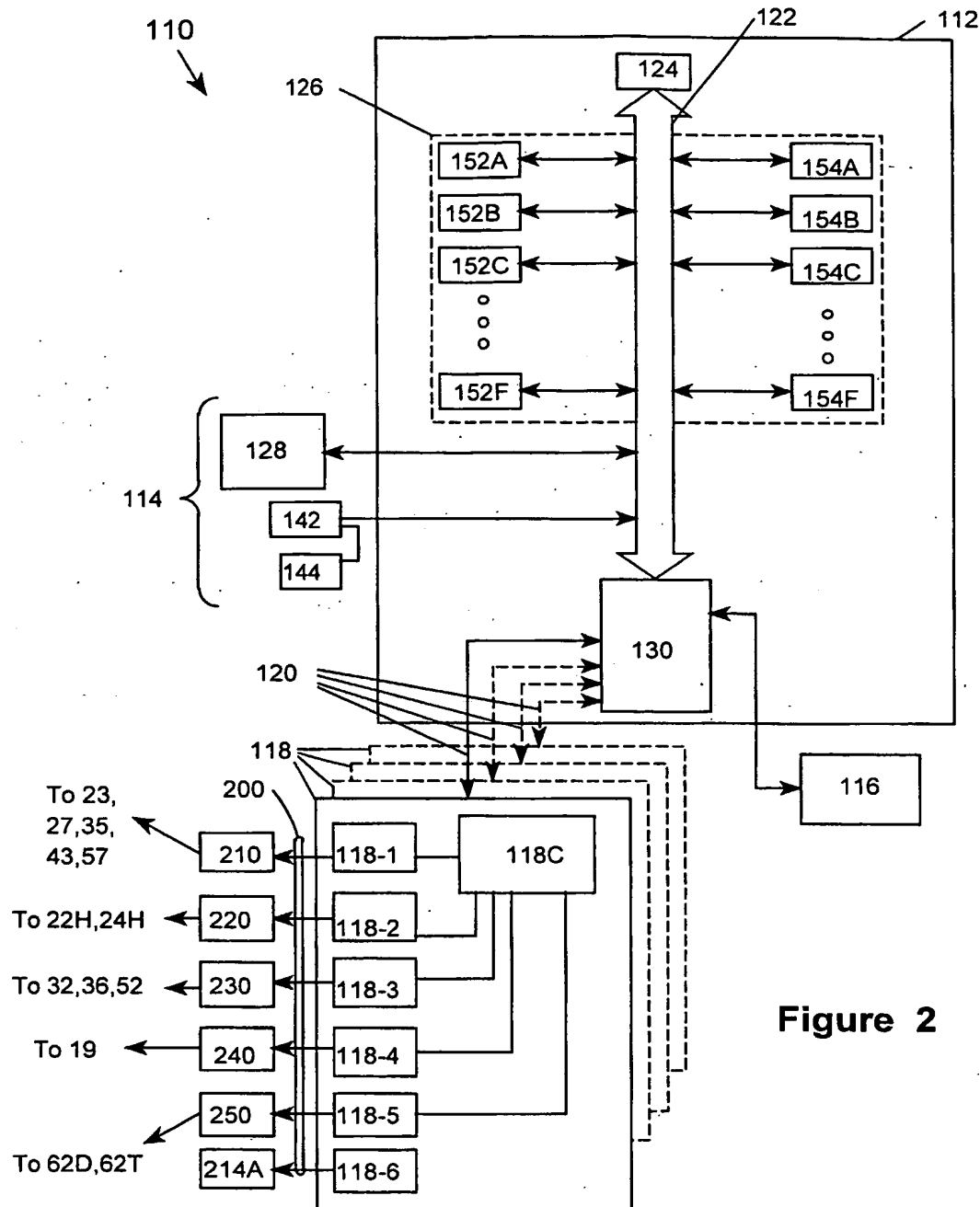


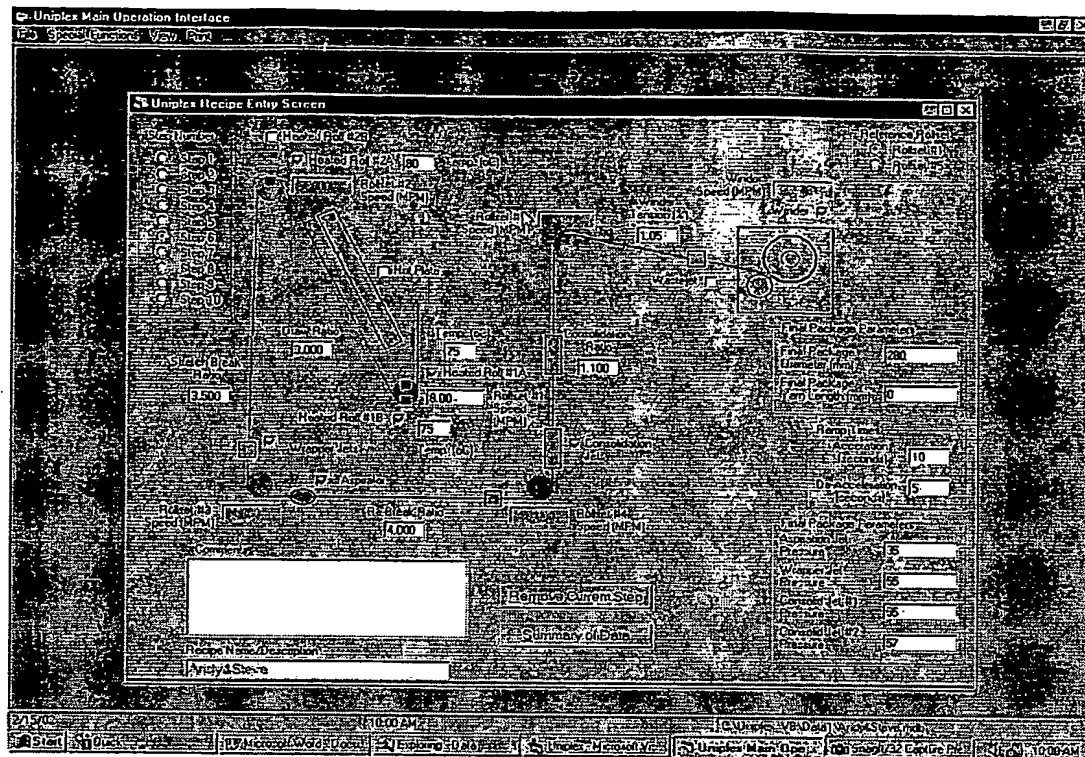
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### Figure 2

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Figure 3



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Figure 4

		Step					
Main Parameters		1	2	3	4	5	6
Production TakeUp - Drive					ON		
Production Take Up	m/min	0.00	0.00	0.00	207.40	312.70	312.70
Take Up Tension	%	0.0	0.0	0.0	0.0	0.0	0.0
Roll-set 5	m/min	0.00	0.00	0.00	207.40	312.70	312.70
Consolidation Ratio	1/x	0	0	0	0.98	0.98	0.98
Roll-set 4	m/min	0.00	0.00	101.46	211.63	319.08	319.08
ReBreak Ratio	1/x	0	0.00	1.83	2.33	2.82	2.82
Roll-set 3	m/min	0.00	0.00	55.44	90.83	113.15	113.15
Stretch Break Ratio	1/x	0.00	0.00	2.20	2.93	3.65	3.65
Roll-set 2	m/min	16.80	20.00	25.20	31.00	31.00	31.00
Draw Ratio	1/x	2.10	2.50	2.80	3.10	3.10	3.10
Roll-set 1	m/min	8.0	8.0	9.0	10.0	10.0	10.0
Aspirator Jet		Off	Off	On	On	On	On
Consolidation Jet		Off	Off	Off	On	On	On
Waste Jet		Off	Off	Off	Off	On	Off
Winder		Off	Off	Off	Off	Off	On

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